

AMENDMENT

Amend the application, without prejudice, as follows:

In the Claims:

This following listing of claims replaces all prior versions, and listings, in the application:

1. (Withdrawn) A yarn carrier for winding yarn thereon comprising:
 - a. a hollow cylindrical tube having a longitudinal axis extending lengthwise between first and second opposite ends thereof and having a substantially cylindrical outer surface, the tube having a recess formed into the first end of the tube, the recess having an inside surface with first and second ends, and a first recess side surface extending from the first end of the inside surface to the first end of the tube; and
 - b. a yarn catch insert adapted to be inserted into the recess, the yarn catch insert having an inside surface with first and second ends, an outside surface, and a first side surface extending between the first end of the inside surface and an outside surface, wherein when the yarn catch insert is inserted into the recess, the inside surface of the yarn catch insert is positioned opposite the inside surface of the recess and a distance between the inside surface of the recess and the inside surface of the yarn catch insert tapers along at least a portion of the inside surface of the recess.
2. (Withdrawn) The yarn catch insert according to claim 1 wherein the distance between the inside surface of the recess and the inside surface of the yarn catch insert tapers to a pinch point.
3. (Withdrawn) The yarn carrier according to claim 1 wherein the distance between the inside surface of the recess and the inside surface of the yarn catch insert tapers in a direction from the first end to the second end of the inside surface of the recess along a portion of the inside surface of the recess and widens in the same direction along a different portion of the inside surface of the recess.
4. (Withdrawn) The yarn carrier according to claim 1 wherein a score is formed in the outer surface of the tube, the score extending circumferentially around the tube and intersecting the inside surface of the recess.

5. (Withdrawn) The yarn carrier according to claim 1 wherein the inside surface of the recess and the inside surface of the yarn catch insert are substantially perpendicular to the longitudinal axis of the tube.

6. (Withdrawn) The yarn carrier according to claim 1 wherein the yarn catch insert comprises a shelf that is positioned radially inward of and extending under the outer surface of the tube when the yarn catch insert is inserted in the recess and the tube includes a channel formed in the first recess side surface adapted to receive the shelf of the yarn catch insert to prevent the yarn catch insert from extending radially outward of the outer surface of the tube.

7. (Withdrawn) The yarn carrier according to claim 1 wherein at least one of the first recess side surface and the first side surface of the yarn catch insert includes teeth for removably securing the yarn catch insert in the recess.

8. (Withdrawn) The yarn carrier according to claim 1 wherein the yarn catch insert flexibly extends from the tube whereby the inside surface of the yarn catch insert may be removably inserted into the recess.

9. (Withdrawn) The yarn carrier according to claim 8 further comprising a void at the second end of inside surface of the recess.

10. (Withdrawn) The yarn carrier according to claim 8 further comprising a void formed in the outside surface of the yarn catch insert to facilitate rotation of the yarn catch insert into the recess.

11. (Withdrawn) The yarn carrier according to claim 8 further comprising teeth formed on at least one of the first recess side surface and the first side surface of the yarn catch insert for removably securing the yarn catch insert in the recess.

12. (Currently Amended) In combination, a yarn catch insert and a yarn winding tube, the insert for insertion into an elongated hole formed through a the yarn winding tube inwardly of the end of the tube, the yarn winding tube comprising:

~~the yarn winding tube being~~ a hollow cylindrical tube body having a longitudinal axis extending lengthwise between first and second opposite ends thereof and having a substantially cylindrical outer surface, the elongated hole completely surrounded by the cylindrical surface, and the elongated dimension of the hole having a plainer side surface with a portion extending in a

circumferential direction around a portion of the circumference of the tube body and substantially perpendicular to the longitudinal axis of the tube body, and

the yarn catch insert comprising:

an inside surface,

an outside surface positioned adjacent the outer cylindrical surface of the tube body
when the insert is positioned within the hole, and

an extended side surface, a portion of the side surface of the insert positioned opposite the portion of the side surface of the hole when the insert is inserted into positioned within the hole, the extended side surface of the insert having a plainer first portion and a second portion formed at an angle with respect to the first portion, the opposing portions of the side surfaces of the insert and the hole forming a circumferential start-up groove ~~inwardly of~~ within the cylindrical outer surface of the tube, at least a portion of the start-up groove being tapered in a direction along the circumference of the tube due to the angular relationship between the first portion and second portion of the side surface of the insert.

13. (Currently Amended) The ~~yarn-catch-insert~~ combination according to claim 12 wherein the yarn catch insert has a flange adjacent to its inside surface for preventing the outside surface of the yarn catch insert from extending beyond the ~~outside~~ outer cylindrical surface of the tube body.

14. (Currently Amended) The ~~yarn-catch-insert~~ combination according to claim 12 wherein an edge between the outside surface of the yarn catch insert and ~~the~~ at least a portion of its the side surface of the insert is radiused.

15. (Currently Amended) The ~~yarn-catch-insert~~ combination according to claim 12 wherein the start-up groove tapers to a pinch point.

16. (Cancelled).

17. (Currently Amended) The ~~yarn-catch-insert~~ combination according to claim 12 wherein the first portion of the side surface of the ~~hole insert~~ insert and the ~~first~~ first corresponding portion of the side surface of the ~~yarn-catch-insert~~ hole are perpendicular to the longitudinal axis of the tube body.

18. (Currently Amended) The ~~yarn-catch-insert~~ combination according to claim 12 wherein the yarn catch insert is comprised of one of plastic, wood, and metal.

19. (Withdrawn) The yarn catch insert according to claim 12 wherein the yarn catch insert comprises a barb extending beyond the portion of its side surface in a direction toward the portion of the side surface of the hole.

20. (Currently Amended) The ~~yarn catch insert~~ combination according to claim 12, wherein the yarn catch insert further comprises a having an lower portion and an upper portion, the lower portion having a width corresponding to the width of the hole in the tube body, the upper portion have a width less than the width of the hole in the tube body, wherein the start-up groove is formed between the side surface of the hole and the upper portion of the yarn catch insert.

21. (Currently Amended) A ~~yarn catch insert~~ combination according to claim 14 wherein the outside surface of the yarn catch insert is tapered radially inwardly when positioned within the hole within the tube body adjacent to the start-up groove.

22. (Currently Amended) A yarn carrier for winding yarn thereon comprising:

- a. a hollow tube having a longitudinal axis extending lengthwise between first and second ends thereof, the tube having an outer cylindrical surface and an elongated hole thru and completely surrounded by the cylindrical surface, the hole positioned inwardly of one end of the tube, the longitudinal dimension of the hole extending in the circumferential direction ~~around a portion of the circumference~~ of the tube; and
- b. a yarn catch insert positioned within the hole formed through the tube, the hole having an extended plainer side surface perpendicular to the longitudinal axis of the tube, the yarn catch insert having an inside surface, an outside surface, and an extended side surface, the extended side surface having a plainer first portion and a plainer second portion, the plainer second portion angled relative to the first portion, a portion of the extended side surface of the insert positioned opposite the portion of the extended plainer side surface of the hole with the first portion parallel to the extended plainer side surface of the hole when the insert is ~~inserted into~~ positioned within the hole, and the extended side surface of the hole and the extended side surface of the insert forming a start-up groove extending in a circumferential direction around the tube, at least a portion of the start-up groove being tapered ~~in the circumferential direction of the tube~~.

23. (Withdrawn) A yarn catch insert adapted to be inserted into a hole formed through a yarn winding tube, the yarn winding tube being a hollow cylindrical tube having a longitudinal axis extending lengthwise between first and second opposite ends thereof and having a substantially cylindrical outer surface, the yarn catch insert comprising:

a. a first member having a first end, a second end opposite the first end, and an inner surface; and

b. a second member having a first end, a second end, and an inner surface facing the inner surface of the first member when the first and second members are positioned in the hole; wherein start-up groove having a tapered portion is formed between the inner surfaces of the first and second members.

24. (Withdrawn) The yarn catch insert according to claim 23 wherein the second end of the first member is coupled to the second end of the second member.

25. (Withdrawn) The yarn catch insert according to claim 23 wherein one of the first and second members has a barb extending beyond its inner surface toward the other member.

26. (Withdrawn) The yarn catch insert according to claim 23 wherein one of the first and second members has a hook extending beyond its inner surface toward the other member.

27. (Withdrawn) The yarn catch insert according to claim 23 wherein the inner surfaces of the first and second members are perpendicular to the longitudinal axis of the tube when they are disposed in the hole.

28. (Withdrawn) The yarn catch insert according to claim 23 wherein the first and second members each have an inside surface and an outside surface, the members comprising a flange extending from their inside surfaces to prevent the yarn catch insert from extending past the outer surface of the tube when positioned within the tube.

29. (Withdrawn) The yarn catch insert according to claim 23 wherein the start-up groove tapers to a pinch point.

30. (Withdrawn) The yarn catch insert according to claim 23 wherein a portion of the start-up groove tapers in a first circumferential direction and a different portion of the start-up groove widens in the same direction.

31. (Withdrawn) The yarn catch insert according to claim 23 further comprising an adhesive applied to an outside surface of at least one of the first and second members.

32. (Withdrawn) A yarn carrier for winding yarn thereon comprising:

a. a hollow cylindrical yarn winding tube having a longitudinal axis extending lengthwise between first and second opposite ends thereof and having a substantially cylindrical outer surface, the tube having a hole extending from a first end, around a portion of the circumference of the tube to its second end and having a first side surface and an opposite second side surface extending between the first and second ends of the hole;

b. a yarn catch insert according positioned within the hole, the yarn catch insert comprising:

a first member having a first end, a second end opposite the first end, and an inner surface; and

a second member having a first end, a second end, and an inner surface facing the inner surface of the first member when the first and second members are positioned in the hole;

wherein start-up groove having a tapered portion is formed between the inner surfaces of the first and second members.

33. (Currently Amended) A yarn carrier for winding yarn thereon comprising:

a hollow cylindrical tube having a longitudinal axis extending lengthwise between first and second opposite ends thereof and having substantially cylindrical inner and outer surfaces, the tube having ~~a non-symmetrical, an~~ elongated hole extending between the inner and outer surfaces of the tube and spaced inwardly from ~~of~~ one end of the tube, such that the hole is surrounded by at least the outer cylindrical surface of the tube, the hole extending longitudinally along the circumference having a plainer side surface with a longitudinal dimension extending in the circumferential direction of the tube, and adapted to accept

an elongated yarn catch insert ~~therein~~ removably secured within the hole in the tube, the insert having an extended side surface, including a first portion and a second portion, the first portion angled with respect to the second portion, the extended side surface of the insert positioned in an opposing relationship with the side surface of the hole, with the first portion spaced from and substantially parallel to the side surface of the hole and the second portion forming a tapered groove with the side surface of the tube, the insert and the side surface of the hole combining to form a yarn catching start-up groove in the yarn carrier.

34. (Original) The yarn carrier according to claim 33 wherein the hole comprises a countersink formed adjacent the inner surface of the tube.

35. (Currently Amended) The yarn carrier according to claim 33 wherein the hole has a width that tapers in a direction from the inside surface to the outside surface of the tube.

36. (Withdrawn) The yarn carrier according to claim 33 wherein the hole has a bulbous head at one end leading to a longitudinal section that widens as it extends from the bulbous head.

37. (Currently Amended) A yarn carrier for winding yarn thereon comprising:

a. a hollow cylindrical inner tube having a longitudinal axis extending lengthwise between first and second opposite ends thereof, the inner tube having a substantially cylindrical outer surface and a longitudinally extending hole formed through the inner tube inwardly of one end thereof and ~~extending along around~~ extending along around a portion of ~~a the~~ the circumference of the tube, the hole directed radially from an inner tube diameter through to ~~it's~~ the outer surface,

b. a hollow cylindrical outer tube having a longitudinal axis extending lengthwise between first and second opposite ends thereof and ~~parallel to~~ coaxially with the longitudinal axis of the inner tube, the outer tube having a substantially cylindrical inner surface with a diameter that is greater than the diameter of the outer surface of the inner tube, and a longitudinally extending hole formed through the outer tube inwardly of one end thereof, such that the hole is surrounded by the outer surface, and the hole in the outer tube having a substantially plainer side surface extending longitudinally in a circumferential direction along a portion of a circumference of the tube,

wherein the inner tube is disposed within the outer tube and wherein the ~~circumferentially extending,~~ longitudinally extending holes in the inner and outer tubes are substantially aligned, and

c. an elongated yarn catch insert removably secured within the holes in the inner and outer tubes, the insert having an extended side surface including a first portion and a second portion, the first portion being angled with respect to the second portion, the extended side surface of the insert positioned in an opposing relationship with the side surface of the hole in the outer tube adjacent the outer surface thereof, with the first portion being spaced from and substantially parallel to the side surface of the hole in the outer tube and the second portion forming a tapered groove with the side surface of the outer tube, the insert and the side surface of the hole in the outer tube combining to form a yarn catching start-up groove adjacent the outer surface of the outer tube.

38. (Original) A yarn carrier according to claim 37 wherein the outer surface of the inner tube comprises ribs for securing the outer tube to the inner tube.

39. (Original) A yarn carrier according to claim 37 wherein the inner tube comprises plastic, metal, wood, or combinations thereof.

40. (Original) A yarn carrier according to claim 37 wherein the outer tube comprises paper.

41. (Original) A yarn carrier according to claim 40 wherein the outer tube has a thickness and the composition of the paper varies along the thickness of the outer tube.

42. (Original) A yarn carrier according to claim 41 wherein the outer tube has an inside portion and an outside portion and the inside portion is softer than the outside portion.

43. (Original) A yarn carrier according to claim 37 wherein the hole of the inner tube has side surfaces that are substantially perpendicular to the longitudinal axis.

44. (Withdrawn) A yarn carrier for winding yarn thereon comprising:

- a. a hollow cylindrical tube having
 - i) a substantially cylindrical outer surface,
 - ii) a first end and a second end, the first and second ends positioned opposite one another with the outer surface of the tube therebetween,
 - iii) an external annular channel adjoining the first tube end, the channel having a base surface radially inward of the outer surface of the tube,
 - iv) a shoulder formed between the outer surface of the tube and the base surface of the channel, the shoulder extending substantially radially inward from the outer surface of the tube to the base surface of the channel, and

v) a recess in the shoulder extending around a portion of the tube circumference and having an inside surface;

b. a ring adapted to be removably retained within the channel, the ring having

i) an ring engagement surface positioned adjacent to the shoulder when the first ring is retained within the channel, the ring engagement surface having a protrusion coinciding with the recess in the first shoulder, the protrusion having a surface cooperating with the inside surface of the recess to form a tapered groove for engaging the yarn during winding startup, and

ii) a first end surface adjoining the first end of the tube adjacent to the channel.

45. (Withdrawn) A yarn carrier according to claim 44 wherein one of the base surface and an inside surface of the ring has ribs for removably securing the ring to the tube.

46. (Withdrawn) A yarn carrier according to claim 44 wherein a score is formed in the outer surface of the tube, the score extending circumferentially around the tube and intersecting the inside surface of the recess.

47. (Withdrawn) A yarn carrier for winding yarn thereon comprising:

a. an inner hollow cylindrical tube having

i) a substantially cylindrical outer surface,

ii) a first end and a second end, the first and second ends positioned opposite one another with the outer surface of the tube therebetween,

iii) an inner tube diameter extending to the outer surface,

b. a outer hollow cylindrical tube having

i) a substantially cylindrical inner surface,

ii) a first end and a second end, the first and second ends positioned opposite one another with the inner surface of the tube therebetween,

iii) an outer tube diameter extending to the inner surface and greater than the inner tube diameter,

iv) a recess formed in the first end of the outer tube;

c. a ring having a first end surface and a second end surface, the first end surface adjoining the first end of the inner tube, the second end surface having a protrusion coinciding with the recess in the outer tube.

48. (Withdrawn) The yarn carrier according to claim 47 wherein the protrusion and the recess coincide to form a tapered start-up groove.

49. (Withdrawn) The yarn carrier according to claim 47 further comprising a circumferential score in the outer tube aligned with the side surface of the recess.

50. (Withdrawn) An apparatus for forming a hole in a hollow cylindrical tube, the tube having first and second opposite ends and substantially cylindrical inner and outer surfaces, the apparatus comprising:

a die having an opening formed therein for receiving a punch and having an outer surface that substantially matches the curvature of at least a portion of the inner surface of the tube, the outer surface of the die extending radially outward in the vicinity of and as it approaches the opening in the die to form a lip, whereby when a hole is punched into the tube by placing the die in the tube and then inserting the punch through the tube and into the opening in the die, a countersink is formed on the inner surface of the tube adjacent to the hole formed in the tube.

51. (Withdrawn) The apparatus according to claim 50 wherein the hole in the die is asymmetrical.